

master unit: 006431 S127270



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Canada

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005900
006287

646.4001
Job Sheet 184036



Part No: 646.4001 Job Qty: 1 ea

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs Status: New Priority: Medium
Job Created: 10/2/18 Job Tracking No: SIOP
Due Date: 11/9/18 Created By: Marie Lajeunesse
Type: Stock Description:

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/9/18		0.00	0.00	Start Up Stores/Pkg-1		OCT 15 2018
110	Packaging	1 pcs	11/9/18		0.00	0.00	Packaging1-1	9-89	NOV 13 2018
120	QC	1 pcs	11/9/18		0.00	0.00	QC4	9-89	NOV 13 2018
130	Packaging	1 pcs	11/9/18		0.00	0.00	Packaging3-1	9-89	NOV 13 2018
135	DC	1 pcs	11/9/18		0.00	0.00	DC		NOV 13 2018
140	QC21-FG	1 Ea	11/9/18		0.00	0.00	QC21		NOV 13 2018

Part Op 130 - Identify and pack for shipping as per PPP 646.4001 Location: _____
Descriptions: 135 - Photocopy bluefile & type labels per PPP 646.4001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	90-Start up Operation	5031229
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5078331
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5079132
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	5082048
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	90-Start up Operation	5066985
646.2910	Deflector	1 Ea (1 ea)	90-Start up Operation	5079498
646.3001	Lower Cable Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	541223
646.3110	Channel	1 Ea (1 ea)	90-Start up Operation	5059056
646.3210	Support	1 Ea (1 ea)	90-Start up Operation	5091495
646.3301	Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5104453
646.3510	Strut	1 Ea (1 ea)	90-Start up Operation	5050453
646.3511	Strut	1 Ea (1 ea)	90-Start up Operation	5063686
646.3610	Filler	1 Ea (1 ea)	90-Start up Operation	5092525
646.3710	Doubler	1 Ea (1 ea)	90-Start up Operation	5049669
646.3711	Clip	1 Ea (1 ea)	90-Start up Operation	5063766
646.3712	Clip	1 Ea (1 ea)	90-Start up Operation	5038797
646.3713	Gusset	1 Ea (1 ea)	90-Start up Operation	5042029
646.3714	Gusset	1 Ea (1 ea)	90-Start up Operation	5038824
646.3715	Strut Doubler	2 Ea (2 ea)	90-Start up Operation	5035970
646.3716	Gauge Bracket	1 Ea (1 ea)	90-Start up Operation	5050290
646.3717	Doubler	1 Ea (1 ea)	90-Start up Operation	5038801
646.3718	Custom Washer	2 Ea (2 ea)	90-Start up Operation	5064802



AS350 Cable Gutter System

PART NO: 646.4001
Serial No/Batch: S127270

Operation: Packaging

Operation:
Change No:

Packaging

Job No: 184036

163 2500

#3 J03 184036

646.3719	Doubler	2 Ea (2 ea)	90-Start up Operation	5003754
646.3810	Bracket	2 Ea (2 ea)	90-Start up Operation	5067214X1
646.3811	Radius Block	1 Ea (1 ea)	90-Start up Operation	5057883
646.3812	Gusset Bracket	2 Ea (2 ea)	90-Start up Operation	5118939
646.3813	AS350 Strut Bracket	1 Ea (1 ea)	90-Start up Operation	5073258
646.3910	Shim	4 Ea (4 ea)	90-Start up Operation	5083586
646.3911	Shim	1 Ea (1 ea)	90-Start up Operation	5041250
646.3912	Shim	4 Ea (4 ea)	90-Start up Operation	5083591
646.3913	Shim	1 Ea (1 ea)	90-Start up Operation	5041498
646.9410	Shim	1 Ea (1 ea)	90-Start up Operation	5056999
647.0112	Strut Bracket	2 Ea (2 ea)	90-Start up Operation	5063624
647.7703	Strut Assembly	2 Ea (2 ea)	90-Start up Operation	5118480
650.9201	Eyelet Bracket Assembly	2 Ea (2 ea)	90-Start up Operation	5092170
AN3-11A	Bolt	10 Ea (10 ea)	90-Start up Operation	5098034
AN3-12A	Bolt	2 Ea (2 ea)	90-Start up Operation	5048376
AN3-13A	Bolt	1 Ea (1 ea)	90-Start up Operation	5098032
AN3-3A	Bolt	4 Ea (4 ea)	90-Start up Operation	5056462
AN3-4A	Bolt	10 Ea (10 ea)	90-Start up Operation	5060063
AN3-5A	Bolt	2 Ea (2 ea)	90-Start up Operation	5095480
AN3-6A	Bolt	2 Ea (2 ea)	90-Start up Operation	5103950
AN316C4R	Nut, Jam	2 Ea (2 ea)	90-Start up Operation	5080637
AN44-5A	Eyebolt	2 Ea (2 ea)	90-Start up Operation	5065262
AN4C7A	Bolt	2 Ea (2 ea)	90-Start up Operation	5095478
AN665-34R	Clevis	2 Ea (2 ea)	90-Start up Operation	5065264
CCR264SS3-02	Cherry Rivet	36 Ea (36 ea)	90-Start up Operation	5116954
CR3213-5-3	Cherry Rivet	14 Ea (14 ea)	90-Start up Operation	5074204
MS20426AD5-7	Rivet	2 Ea (2 ea)	90-Start up Operation	7153848
MS20470AD5-5.5	Rivet	8 Ea (8 ea)	90-Start up Operation	71134063
MS20470AD5-6	Rivet	8 Ea (8 ea)	90-Start up Operation	7124089
MS20470AD5-7	Rivet	3 Ea (3 ea)	90-Start up Operation	7123425
MS21042L08	Nut	2 Ea (2 ea)	90-Start up Operation	5106409
MS21042L3	Nut	63 Ea (63 ea)	90-Start up Operation	5094592
MS21042L4	Nut	2 Ea (2 ea)	90-Start up Operation	5094597
MS21047-3	Nut Plate	18 Ea (18 ea)	90-Start up Operation	5103943
MS24693-C278	Screw	5 Ea (5 ea)	90-Start up Operation	5065341
MS24694-S51	Screw	5 Ea (5 ea)	90-Start up Operation	5004859
MS24694-S54	Screw	2 Ea (2 ea)	90-Start up Operation	5080642
MS24694-S55	Screw	3 Ea (3 ea)	90-Start up Operation	5050050
MS27039-08-13	Screw	2 Ea (2 ea)	90-Start up Operation	5016508
MS27039-1-10	Screw	2 Ea (2 ea)	90-Start up Operation	5071830
MS27039-1-12	Screw	6 Ea (6 ea)	90-Start up Operation	5006971
MS27039-1-16	Screw	24 Ea (24 ea)	90-Start up Operation	5115626
MS27039-1-19	Screw	22 Ea (22 ea)	90-Start up Operation	5071413
MS27039-1-20	Screw	2 Ea (2 ea)	90-Start up Operation	5000680
MS27039-1-21	Screw	4 Ea (4 ea)	90-Start up Operation	5037684
NAS1149F0332P	Washer	144 Ea (144 ea)	90-Start up Operation	5103666
NAS1149F0363P	Washer	2 Ea (2 ea)	90-Start up Operation	5075330
NAS1149F0432P	Washer	4 Ea (4 ea)	90-Start up Operation	5083558
NAS1149FN832P	Washer	4 Ea (4 ea)	90-Start up Operation	5100408

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.0129	8	280	0
	600.0990	1	12	0
	600.0991	1	12	0
	600.1012	1	14	0
	600.1013	5	34	0
	646.2910	1	27	0
	646.3001	1	5	0
	646.3110	1	3	0
	646.3210	1	16	0
	646.3301	1	8	0
	646.3510	1	19	0

646.3511	1	24	0
646.3610	1	24	0
646.3710	1	50	0
646.3711	1	34	0
646.3712	1	22	0
646.3713	1	17	0
646.3714	1	23	0
646.3715	2	33	0
646.3716	1	40	0
646.3717	1	26	0
646.3718	2	44	0
646.3719	2	36	0
646.3810	2	8	0
646.3811	1	31	0
646.3812	2	2	0
646.3813	1	13	0
646.3910	4	33	0
646.3911	1	23	0
646.3912	4	30	0
646.3913	1	39	0
646.9410	1	101	0
647.0112	2	108	0
647.7703	2	1	0
650.9201	2	17	0
AN3-11A	10	219	0
AN3-12A	2	108	0
AN3-13A	1	103	0
AN3-3A	4	293	0
AN3-4A	10	431	0
AN3-5A	2	290	0
AN3-6A	2	206	0
AN316C4R	2	43	0
AN44-5A	2	33	0
AN4C7A	2	149	0
AN665-34R	2	35	0
CCR264SS3-02	36	429	0
CR3213-5-3	14	286	0
MS20426AD5-7	2	1,061	0
MS20470AD5-5.5	8	237	0
MS20470AD5-6	8	1,022	0
MS20470AD5-7	3	146	0
MS21042L08	2	2,540	0
MS21042L3	63	3,017	0
MS21042L4	2	3,955	0
MS21047-3	18	536	0
MS24693-C278	5	154	0
MS24694-S51	5	123	0
MS24694-S54	2	36	0
MS24694-S55	3	204	0
MS27039-08-13	2	197	0
MS27039-1-10	2	214	0
MS27039-1-12	6	123	0
MS27039-1-16	24	543	0
MS27039-1-19	22	277	0
MS27039-1-20	2	117	0
MS27039-1-21	4	122	0
NAS1149F0332P	144	3,011	0
NAS1149F0363P	2	586	0
NAS1149F0432P	4	1,226	0
NAS1149FN832P	4	3,526	0

Part Specifications

Specifications could not be found.

recto verso



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
005900	S118384	600.0129	VHB Tape	S031229	CCK096	8
005900	S118385	600.0990	Magnabond 6398 Part A Size 112 ml	S078331	PKG	1
005900	S118386	600.0991	Magnabond 6398 Part B Size 112 ml	S079132	PKG	1
005900	S082043	600.1012	Sealant PR1425B2 (#654 sem)	S078164	CCK017	1
005900	S118387	600.1013	021200-3M Tape Primer 94 Primer 24216	S066985	CCK096	5
005900	S118388	646.2910	Deflector	S079498	CCK050	1
005900	S118389	646.3001	Lower Cable Cutter Assembly	S111223	CCK023	1
005900	S059056	646.3110	Channel	S059055	CCK020	1
005900	S118390	646.3210	Support	S091495	CCK020	1
005900	S118391	646.3301	Upper Cutter Assembly	S104453	CCK018	1
005900	S118392	646.3510	Strut	S050453	CCK103	1
005900	S118393	646.3511	Strut	S063686	CCK103	1
005900	S118394	646.3610	Filler	S092525	CCK103	1
005900	S118395	646.3710	Doubler	S049669	CCK006	1
005900	S118396	646.3711	Clip	S063766	CCK104	1
005900	S118397	646.3712	Clip	S038797	CCK104	1
005900	S118398	646.3713	Gusset	S042029	CCK104	1
005900	S118399	646.3714	Gusset	S038824	CCK104	1
005900	S118401	646.3715	Strut Doubler	S035990	CCK105	2
005900	S118402	646.3716	Gauge Bracket	S050290	CCK105	1
005900	S118403	646.3717	Doubler	S038801	CCK105	1
005900	S118404	646.3718	Custom Washer	S064802	CCK105	2
005900	S118405	646.3719	Doubler	S063754	CCK105	2
005900	S118406	646.3810	Bracket	S067214	CCK105	2
005900	S118407	646.3811	Radius Block	S057883	CCK105	1
005900	S118408	646.3813	AS350 Strut Bracket	S073258	CCK105	1
005900	S118409	646.3910	Shim	S083586	CCK105	4
005900	S118410	646.3911	Shim	S041250	CCK105	1
005900	S118411	646.3912	Shim	S083591	CCK105	4
005900	S118412	646.3913	Shim	S041498	CCK105	1
005900	S118413	646.9410	Shim	S056998	CCK011	1
005900	S118414	647.0112	Strut Bracket	S063624	CCK106	2
005900	S118415	650.9201	Eyelet Bracket Assembly	S092170	CCK127	2
005900	S117984	AN3-11A	Bolt	S098034	ST349	10

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
005900	S117983	AN3-12A	Bolt	S048376	ST349	2
005900	S117969	AN3-13A	Bolt	s098032	ST349	1
005900	S117954	AN3-3A	Bolt	s056462	ST350	4
005900	S117935	AN3-4A	Bolt	s060063	ST350	10
005900	S117936	AN3-5A	Bolt	S095480	FP001	2
005900	S117912	AN3-6A	Bolt	s103950	ST350	2
005900	S117902	AN44-5A	Eyebolt	S065262	ST339	2
005900	S117894	AN4C7A	Bolt	s095478	ST345	2
005900	S117887	AN665-34R	Clevis	s065264	ST330	2
005900	S117879	CR3213-5-3	Cherry Rivet	s074204	ST319	14
005900	S117873	MS20426AD5-7	Rivet	f153848	ST311	2
005900	S117869	MS20470AD5-5.5	Rivet	fm134063	ST309	8
005900	S117853	MS20470AD5-6	Rivet	f124089	ST309	8
005900	S117844	MS20470AD5-7	Rivet	f123425	ST309	3
005900	S117836	MS21042L08	Nut	s100409	ST303	2
005900	S117818	MS21042L3	Nut	s094592	ST303	63
005900	S117800	MS21042L4	Nut	s094597	ST303	2
005900	S117793	MS21047-3	Nut Plate	s103943	ST301	18
005900	S117789	MS24693-C278	Screw	s065341	ST287	5
005900	S117780	MS24694-S51	Screw	s004859	ST284	5
005900	S117777	MS24694-S54	Screw	s080642	ST284	2
005900	S117770	MS24694-S55	Screw	s050050	ST283	3
005900	S117766	MS27039-08-13	Screw	s016508	ST278	2
005900	S117755	MS27039-1-10	Screw	s071834	ST280	2
005900	S117752	MS27039-1-12	Screw	s006971	ST280	6
005900	S117745	MS27039-1-16	Screw	s115626	ST280	24
005900	S117735	MS27039-1-19	Screw	s071413	ST280	22
005900	S117728	MS27039-1-20	Screw	s000680	ST280	2
005900	S117725	MS27039-1-21	Screw	s037684	ST280	4
005900	S117716	NAS1149F0332P	Washer	s103666	ST262	144
005900	S117707	NAS1149F0363P	Washer	s075330	ST262	2
005900	S117702	NAS1149F0432P	Washer	s083558	ST262	4
005900	S117698	NAS1149FN832P	Washer	s100408	ST260A	4

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 10/15/18 2:15 PM Dart.joly.jocelyne

REFERENCE ONLY

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NOTES:

1 AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.

2 INSTALL F/N 14 WITH F/N 52 & 53.

3 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMASTER-CARR P/N 75935A651.

4 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021200-24216.

5 REUSE FASTENERS FROM F/N 1.

6 USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.

7 AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.

8 INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT, REMOVE SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.

9 NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

REFERENCE ONLY

UNINCORPORATED ECN(s)

05304

5		5		5	78	601.3875	SCREW			
1		1		1	77	646.9410	SHIM			
		4		4	76	601.2764	WASHER		HA51187H830P	
		2		2	75	601.2973	LOCKNUT		MS21042-08	
		2		2	74	601.2988	SCREW		MS27039-0813	
		2		2	73	601.2943	LOCKNUT		MS21042-5	
		2		2	72	601.3128	NUT		AN216C4R	
		2		2	71	601.3209	LOCKNUT		MS21042L4	
		4		4	70	601.2638	WASHER		HA51149H0450P	
		2		2	69	601.2669	BOLT		AN4C1A	
		2		2	68	601.3119	CLEVIS		AN665-308	
		2		2	67	601.3121	EYE BOLT		AN44-5A	
		2		2	66	650.9201	EYE BRACKET ASSY			
	REF	REF		REF	65	647.5701	GPS MOUNT KIT			
				2	64	601.3151	WASHER		HA51149H0303P	
		24		24	63	601.2911	SCREW		MS2664F4553	
		2		2	62	601.2637	SCREW		MS27039-1-16	
	2			2	61	601.2763	BOLT		AN3-12A	
		1		1	60	646.3913	SHIM			
		4		4	59	646.3912	SHIM			
		1		1	58	646.3911	SHIM			
		4		4	57	646.3910	SHIM			
		5		5	56	600.1013	PRIMER			
		8 FT		8 FT	55	600.0129	VHB TAPE			
		1		1	54	600.1012	SEALANT		PR-145 CLASS B	
		1		1	53	600.0991	MAGNOROND 6398 PART B			
		1		1	52	600.0990	MAGNOROND 6398 PART A			
	6	10		10	51	601.2826	BOLT		AN3-11A	
				2	50	646.3814	WIPER BRACKET			
				2	49	601.2910	SCREW		MS27039-1-18	
		2		2	48	601.1365	SCREW		MS27039-1-10	
		2		2	47	646.3719	DOUBLER			
				2	46	646.3718	CUSTOM WASHER			
		1		1	45	646.3717	DOUBLER			
		22		22	44	601.1948	SCREW		MS27039-1-19	
		2		2	43	601.1952	SCREW		MS27039-1-20	
				4	42	601.1956	SCREW		MS27039-1-21	
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

REV.	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 02199, 0231, 0271 & 0276	03/06/2010	P. BRAVO
B	INCORPORATED ECN 02046, 02079 & 04731	11/04/2014	P. BRAVO
C	INCORPORATED ECN 02058	09/09/2015	P. BRAVO

		2	2	41	601.2829	SCREW	MS24694554			
		2	2	40	601.2831	RIVET	MS20426ADS-7			
		1	1	39	646.3716	GAUGE BRACKET				
		6	6	38	601.1953	SCREW	MS27039-1-12			
	2	2	2	37	646.3715	STRUT DOUBLER				
			2	36	601.2824	BOLT	AN3-5A			
12	36		36	35	601.2277	RIVET	CCRG4553-02			
6	18		18	34	600.0795	NUTPLATE	MS21047-3			
3	3		3	33	601.2565	RIVET	MS20470ADS-7			
1	1		1	32	646.3813	STRUT BRACKET				
4	4		4	31	601.2822	BOLT	AN3-5A			
2	2		2	30	646.3812	GUSSET BRACKET				
8	8		8	29	601.2564	RIVET	MS20470ADS-6			
1	1		1	28	646.3714	GUSSET				
	1	1	1	27	646.3610	FILLER				
	3	3	3	26	601.2830	SCREW	MS24694555			
	2	2	2	25	601.2825	BOLT	AN3-5A			
	1	1	1	24	646.3811	RADIUS BLOCK				
	1	1	1	23	646.3712	CLIP				
	1	1	1	22	646.3711	CLIP				
	8	8	8	21	601.2832	RIVET	MS20470ADS-8.5			
14	14		14	20	601.2020	RIVET	CR3213-5-3			
4	6	4	6	19	601.2823	BOLT	AN3-4A			
	1	1	1	18	601.2827	BOLT	AN3-13A			
	5	5	5	17	601.2912	SCREW	MS24694551			
	1	1	1	16	646.3713	GUSSET				
	1	1	1	15	646.3210	SUPPORT				
		1	1	14	646.3710	DOUBLER				
	1	1	1	13	646.3110	CHANNEL				
14	10	8	53	6	601.1624	LOCKNUT	MS210424-3			
16	32	18	120	16	601.1607	WASHER	MS2104252P			
				1	646.3410	LH WIPER DEFLECTOR				
				9	646.3411	RH WIPER DEFLECTOR				
		2		8	647.7703	STRUT ASSY				
		2		7	647.0112	STRUT BRACKET				
	1	1		6	646.3511	STRUT				
	1	1		5	646.3510	STRUT				
2		2		4	646.3810	BRACKET				
			1	3	646.2910	DEFLECTOR				
	1	1		2	646.3001	LOWER CUTTER ASSY				
		1		1	646.3301	UPPER CUTTER ASSY				
X					646.4006	LOWER CUTTER FIXED PROVISIONS				
	X				646.4005	LOWER CUTTER REMOVABLE PROVISIONS				
		X			646.4004	FIXED PROVISIONS KIT				
			X		646.4003	CABLE CUTTERS KIT WITHOUT FIXED PROVISIONS				
				X	646.4002	AS350 WIPER DEFLECTOR KIT				
				X	646.4001	AS350 CABLE CUTTERS KIT				
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

QTY		NEXT ASSY (S)		ORIGINAL DATE: 08-27-08 DRAWN BY: J. CRECHER I. HUFF DRAWING APPROVAL: P. BRAVO 08/27/08 CONTRACT NO:		DART AEROSPACE 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760) 724-5300	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: FINISH DECIMALS ±.010 FINISH DECIMALS ±.005 ANGLES ±.5°		SIZE	SCALE	DATE	REV.	AS350 CABLE CUTTERS KIT 646.4000 SCALE: NONE SHEET 1 OF 5	

REFERENCE ONLY

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